

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027891**Date Inspected:** 30-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job site**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

Ultrasonic Testing (Tower ESW-E-045- "B" from Y=0~3800 Face B)

This QAI performed 100% Joint Ultrasonic Testing (UT), together with ABF QC inspector John Pagliero, on the Tower Complete Joint Penetration (CJP) butt joint shear plate connection designated as ESW-E-045- "B" from Face B. The QA/QC joint inspection team did not observe transverse indications from Y=0~3800 from Face B at the time of inspection. A total of one (1) recordable planar longitudinal indication was observed at the time of inspection. The indication details are as follows

Y=1090, X= +10, Sound Path=164, Depth=53, Length 50mm, +8 db Rating

The QA/QC joint inspection on this date was performed in accordance with AWS D1.5-2002, section 6, table 6.4 and supplemental procedure SE-UT-D1.5-CT-108-ESW-R5.

During the QA Ultrasonic inspection while scanning for transverse indications on the weld designated as ESW-E-045- "B", Face B and at Y location 2730, a sharp ultrasonic response was observed at 68mm in depth. Due to the sharp Ultrasonic response, the QA inspector performed magnetic Particle testing on the opposite face and observed a 20mm linear indication in the base metal adjacent to the weld as seen in the attached photograph.

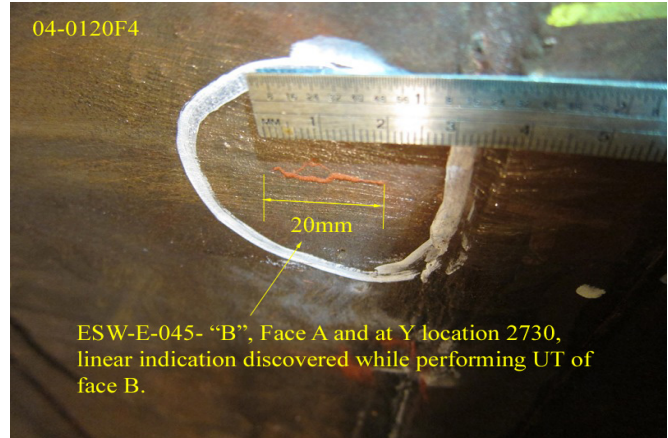
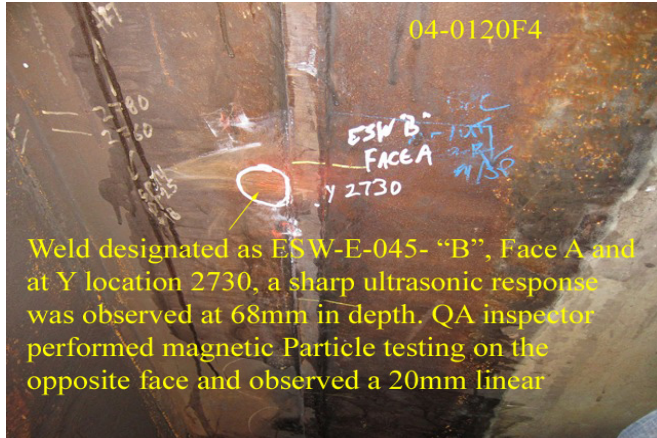
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer
